

Derew 58023

Work Order ID 53475



Page 1

November 6, 2009 8:40:05 AM

Item ID: D3391-021
Revision ID: H
Item Name: Fwd Tube Assembly

Accept



Setup Start
Stop



Start Date: 05/11/2009 Start Qty: 1.00
Required Date: 13/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: BA Date: 09-11-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H

100	Skidtubes	0.00							
	Memo	0.00							
	Cut extrusion to 46.52 +0.010 -0.020								

DP

9-11-23

110	BENDING MACHINE - SKIDTUBES	0.00							
	Memo	0.00							
	Bend as per Dwg D3391 Using Bend Prog 3391021								

1 9/11/24

120	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

h2 6.700"
L° = 13.°

→ 509/124

20

6

Work Order ID 53475

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Page 2

Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00				1	0		
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>44</u> & Dwg D3391 Rev. <u>H</u> Identify as D3391-1 2-Deburr								
140 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				1	0		
Quality Control									
150 	CONVENTIONAL MILLING MACHINE	0.00							
Mill Conv	Memo	0.00				1	0		
Conventional Milling Machine	Drill X1 Aft cap as per Dwg D3391 .1875" dia								

Work Order ID 53475

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Page 3

Item ID: D3391-021

Accept

Revision ID: H

Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00

Required Date: 13/11/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:



Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	mmz 09/12/11			2	0		
170  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SA 09/12/11			1	0		

Work Order ID 53475

November 6, 2009 8:40:05 AM



Page 4

Item ID: D3391-021
Revision ID: H
Item Name: Fwd Tube Assembly

Accept



Setup Start



Stop



Start Date: 05/11/2009 Start Qty: 1.00
Required Date: 13/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")								
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step								
	3-Open tow cap holes to .208" as per Dwg D3391								
	4-Open Tow Ring hole to .640" as per Dwg D3391								
	5- open float bag holes 0.328" and counter sink as per dwg D3391								
	6-Deburr & Scribe Batch number Inside aft end.								
	7-Transfer drill D3391-021 with D3391-023								
190	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

11/9/12/15

27 S. 08/12/15

40

Work Order ID 53475

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
	Hand Finishing								
	Memo								
210	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								
	Memo								
220	Skidtubes	0.00							
	Skidtubes	0.00							
	Skidtubes								
	Memo								
	1-instal spacers as per dwg D3391								
	A/R Magnabond 6398 batch: 9112417								
	exp. date: 11/11/11								
	cure time 12hrs. as per QSI015								
	2- grind crossbolt flush								
	3-back drill crossbolt if necessary								

November 6, 2009 8:40:05 AM

Start Date:	05/11/2009	Start Qty:	1.00
Required Date:	13/11/2009	Req'd Qty:	1.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/
Work Center ID

230

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ Run Hours

0.00

0.00

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

Accept	Qty
--------	-----

Reject
QtyReject
Number

**Insp.
Stamp**

240

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: 3:40
OVEN TEMPERATURE: 320°
FINISH TIME: 4:10

0.00

0.00

250

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

255

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

①

BR 10-4-21

257

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Solal/21

④

260

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

W6056673
D412-742-043

①

BR 10-4-21

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/22 *[Signature]*
mf
10-4-21

Picklist Print

Page 1

November 6, 2009 8:47:16 AM

Work Order ID: 53475

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D6013-047RevA Manufactured No



Skidtube Material

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

57

23935

5

26547

52

D3670-4-200RevA Manufactured No



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

131

46106

4

48198

42

48269

85

D3401-041RevB Manufactured No



Tow.Cap Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

36216

1

41931

5

46029

16

DP 9-11-23

①

④ 11/12/15

BR.
10-3-4.

Picklist Print

Page 2

November 6, 2009 8:47:16 AM

Work Order ID: 53475



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD 		Manufactured	No			255	Each	54.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17-56283

42

51611

32

52059

10

Main Warehouse

ST

12

45409

2

46495

10

D3566-13RevC

Manufactured No

255

Each

31.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP-53461

29

51606

29

Main Warehouse

ST

2

45717

1

50265

1

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Shop Packet Print

Page 2

Picklist Print

November 6, 2009 8:47:16 AM

Work Order ID: 53475

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly


Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			255	Each	3,956.000	10.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

103585

100

100

Main Warehouse

ST

3856

112116

628

112612

2228

112933

1000

AN3C4A

Purchased

No

255

Each

994.0000

10.0000

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

994

112314

13

112720

12

112724

3

112794

366

112829

500

112991

100

Picklist Print

Page 4

November 6, 2009 8:47:16 AM

Work Order ID: 53475

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672 RevB Phenolic Washer		Manufactured	No			255	Each	1,860.000	4.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1360
39275	19
42329	5
47628	336
52505	1000

Main Warehouse

ST117	500
51674	500

AELS-1032-130 1154-1032-130 Purchased No



INSERT

AELS-1032-225 1154-1032-225 Purchased No



INSERT

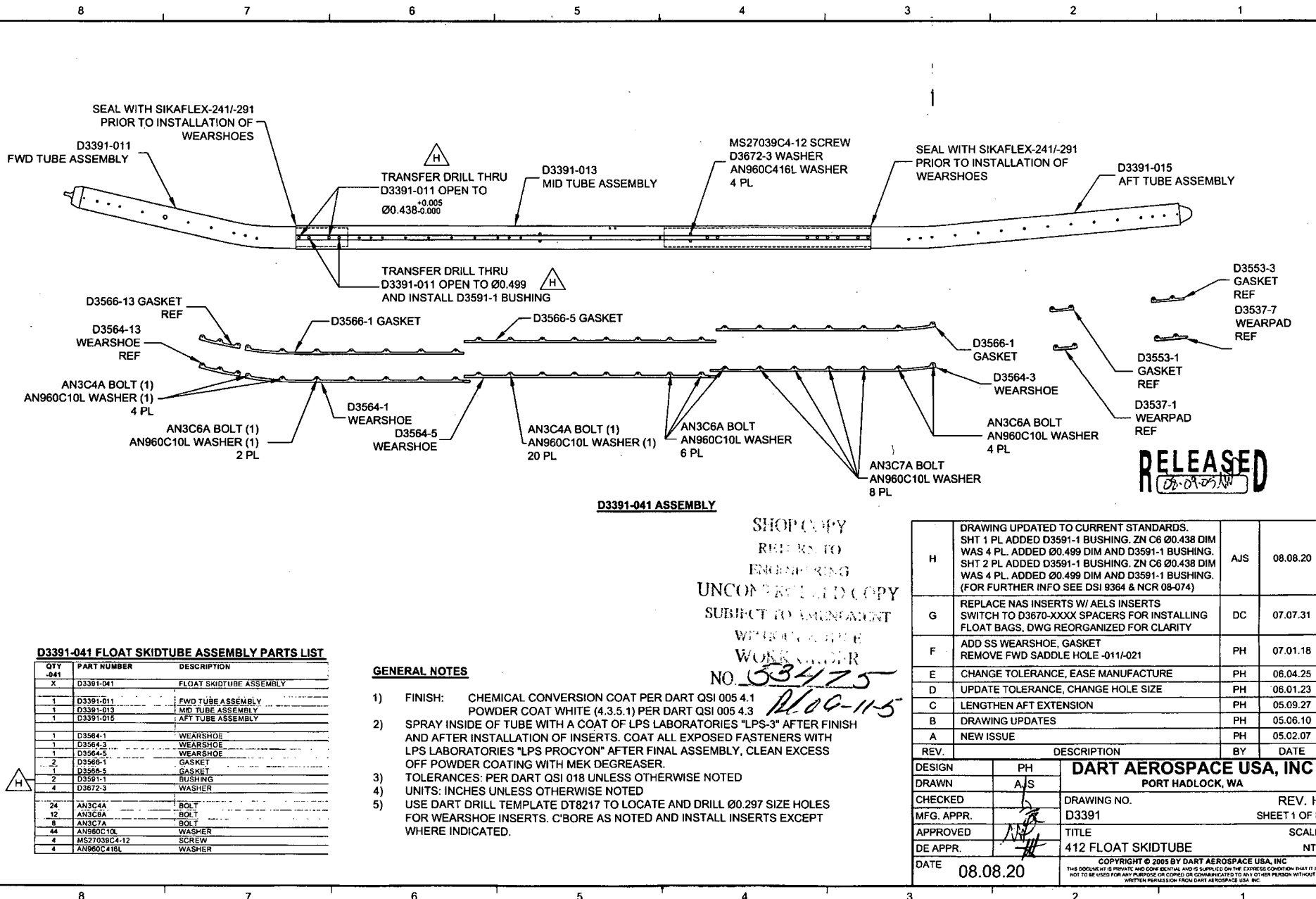
11054

110768

BR 10-3-4.

2 BR 10-3-4.

10 BR 10-3-4.



D3391-041 ASSEMBLY

SHOP COPY
REFERS TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT THE
WORK ORDER
NO. **63475**
100-115

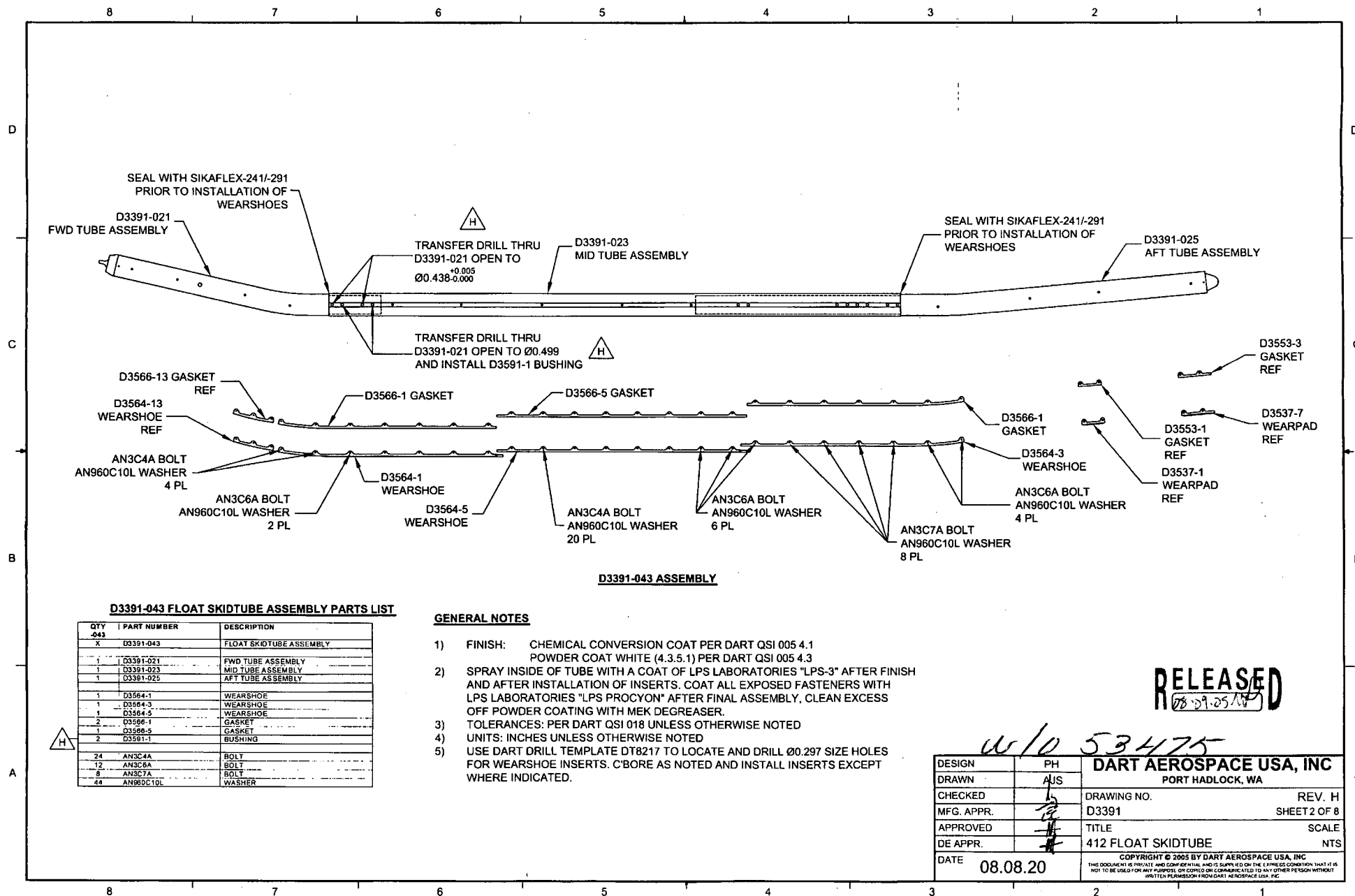
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

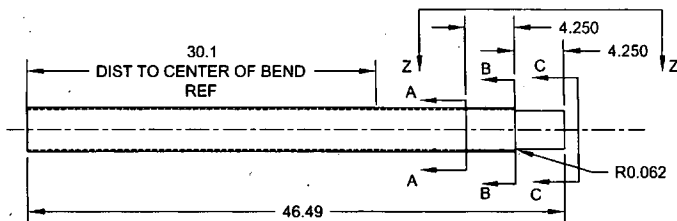
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

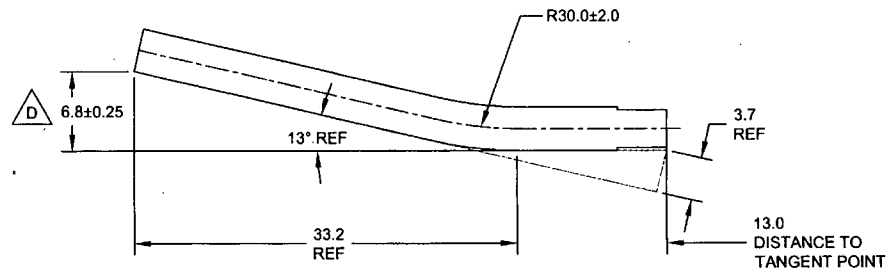
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

RELEASED
08-09-25/10

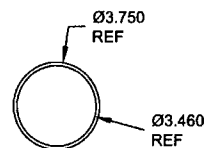
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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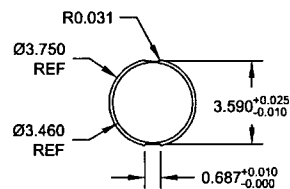
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



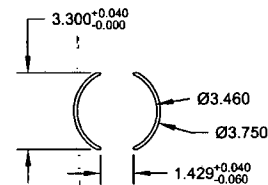
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



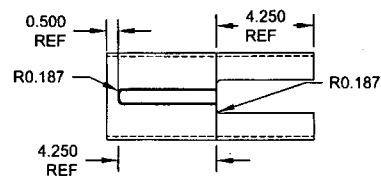
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

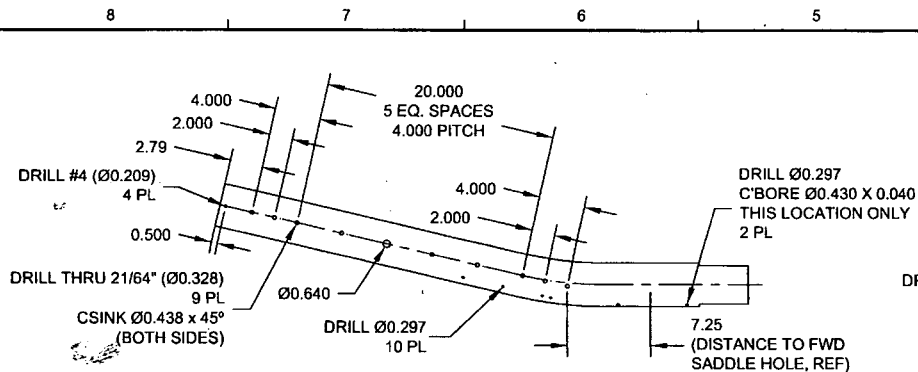


VIEW Z-Z
SCALE 2X

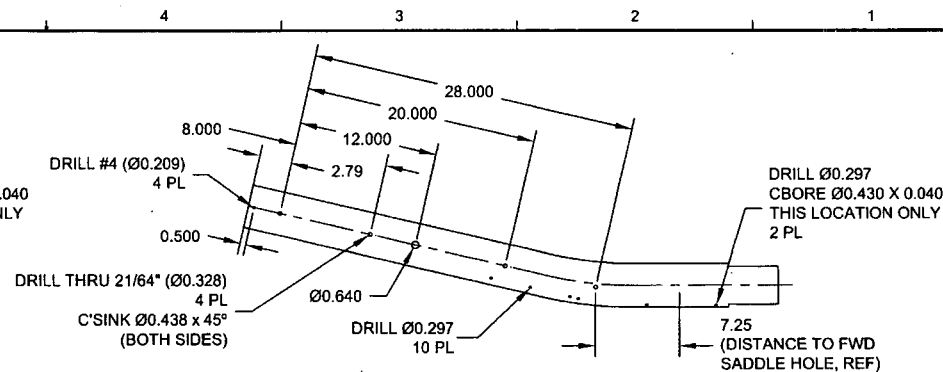
W/053475

RELEASED
08-05-11

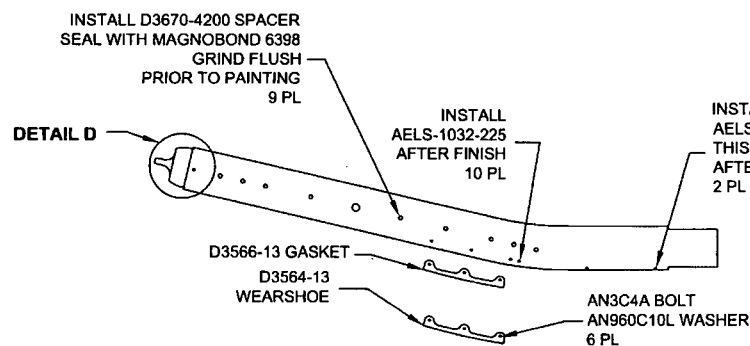
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	



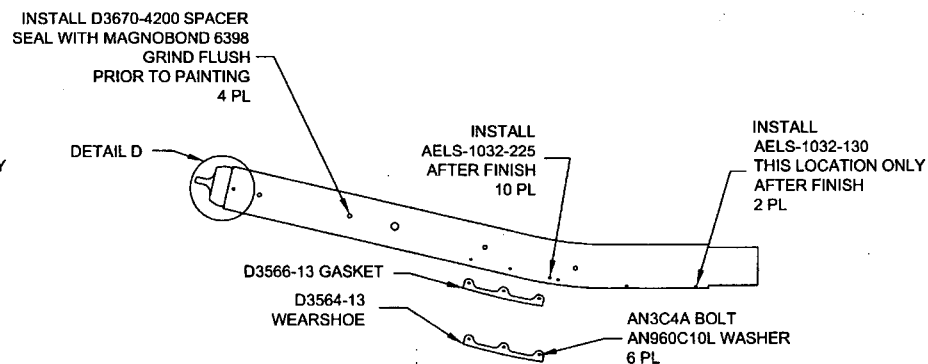
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



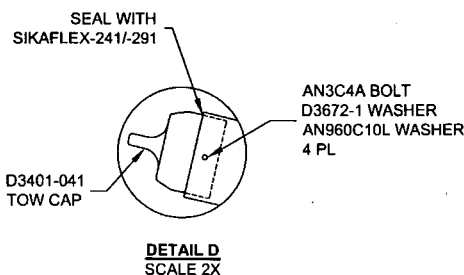
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

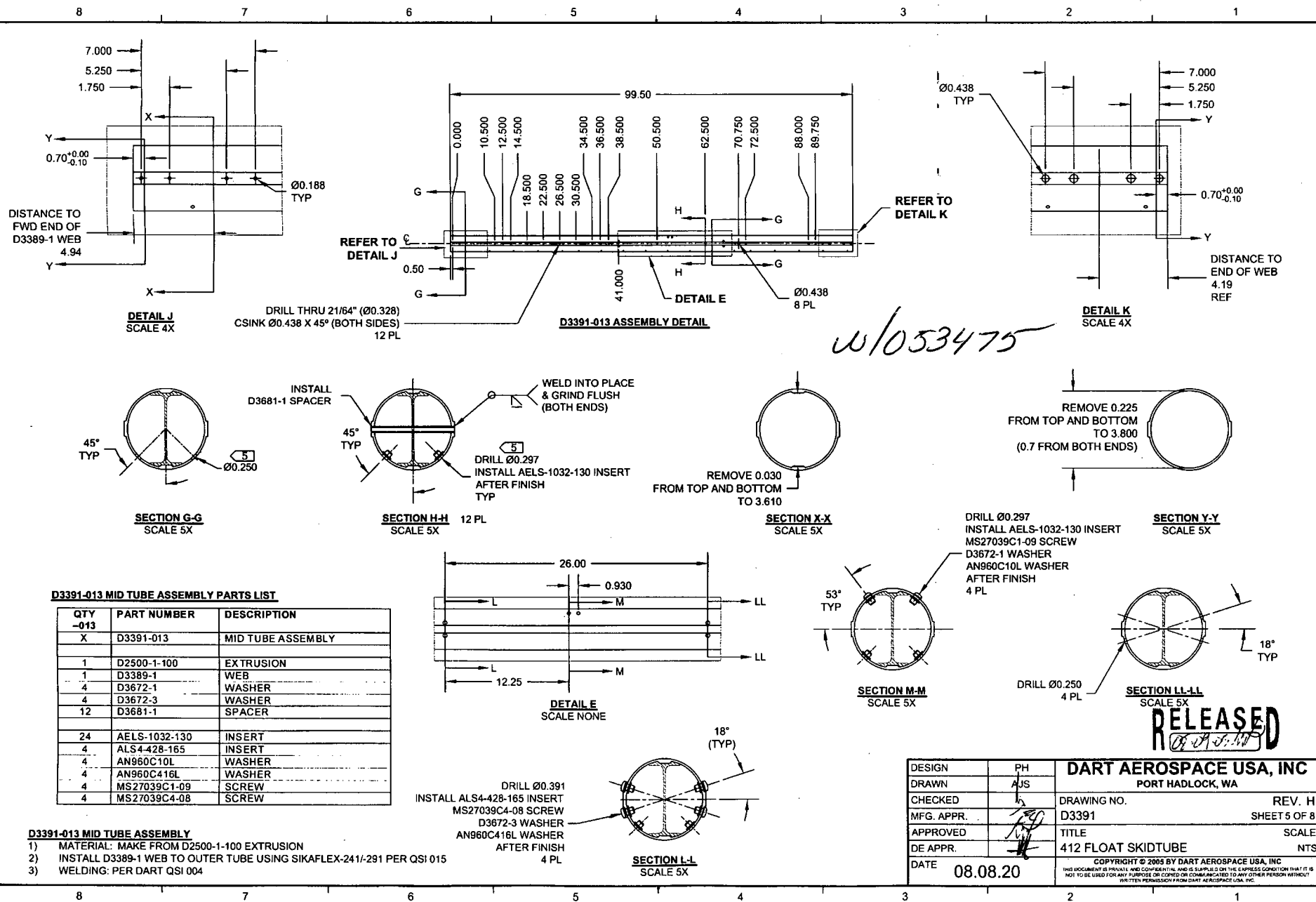
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT



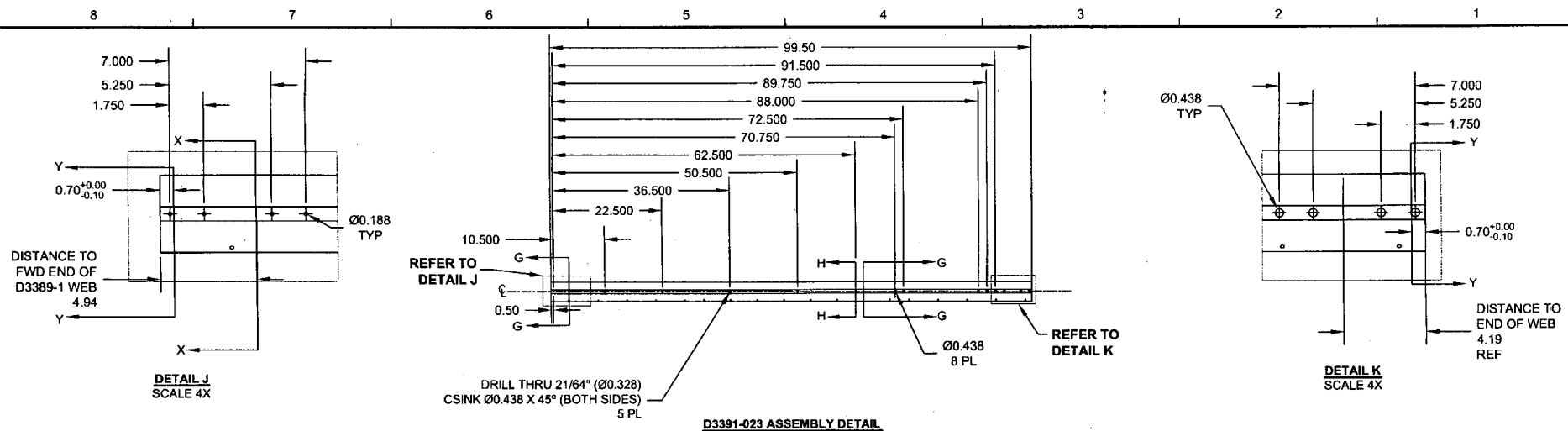
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RELEASED

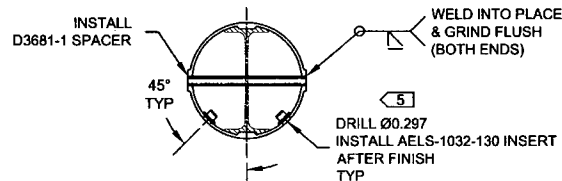
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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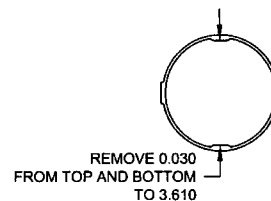
DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
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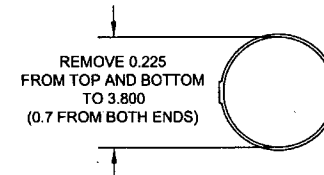
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

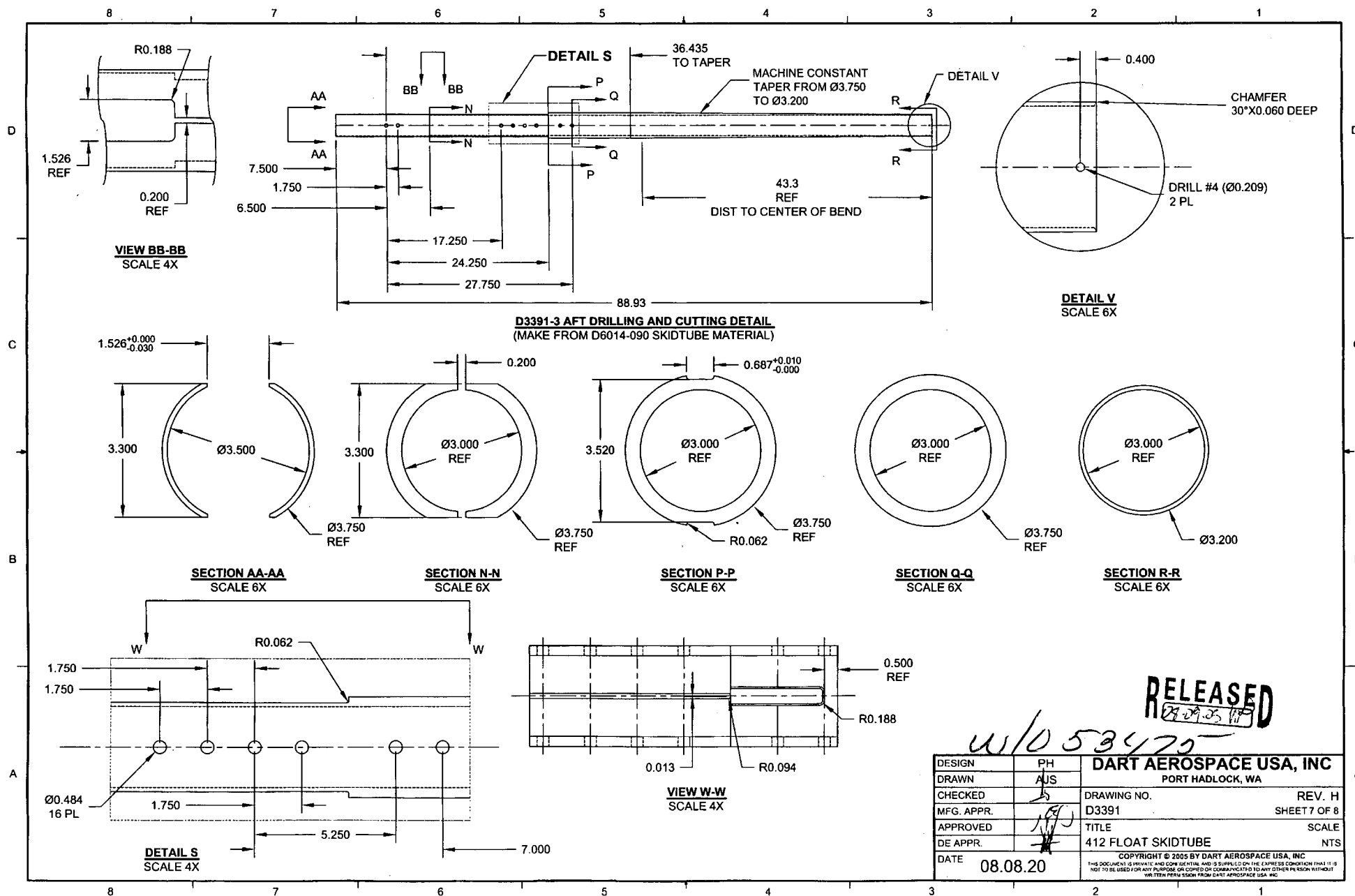
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

w/053475 **RELEASED**

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